

Thursday, April 13, 2017 2:39:17 PM

159634

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 4/19/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/3/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: SCHEDULED

DAS

21

9-89

Approvals: Process Plan: 21 Date: APR 18 2017 Tooling: 9-89 Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D4634	G
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100

0.00

100

HandThermo

Hand Finishing Thermoforming

Memo

Pick Kit

0.00

DAS

07

9-89

17/06/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
21-9 79 08-8						Completed By			
						Lead hand / Supervisor Approval Verification			
						QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

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159634

Page 2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 159634***159634***

Page 3

Thursday, April 13, 2017 2:39:17 PM

Item ID: D4634-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Panel Assembly
Start Date: 4/19/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location PLG	0.00					DAS 6		
130						1	9-89		
Packaging	Memo	0.01						JUN 07 2017	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							17/6/12
Quality Control									

JUN 07 2017

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS		Engineering Quality Other									
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐							
NCR No. _____		Suspected Unapproved ☐		QTY Effective: _____											
Date: _____		Step #: _____		Disposition				MRB (QS1042) Approval							
Description Work Order Deviation															
				Completed By											
				Lead hand / Supervisor Approval Verification											
				QC / QA Coordinator Approval											
Root Cause				FAULT CATEGORY											
Environment ☐				Pressure/Forced ☐				Temperature/Cure ☐				Power Loss/Surge ☐			
Design ☐				Operator ☐				Set-up ☐				Folio/Program ☐			
Doc/Data ☐				Offset/Setup ☐				BOM/Route ☐				Grain ☐			
Equip/Tooling ☐				Supplier ☐				Broken/Damage/Defect ☐				Weld ☐			
Handling/Pre ☐				Training ☐				Crimp/Kink/Ripple/Wave ☐				Wrong Stock Pulled ☐			
Material ☐				Use for Testing ☐				Cracks ☐				Out of Sequence ☐			
Internal Transport ☐				Poor Information ☐				Cuffs ☐				Contamination ☐			
Tribal Knowledge ☐				Rushing ☐				Crushing ☐				Countersink ☐			
LOA ☐				Product Improvement ☐				Heat Treat ☐				Cut Too Short ☐			
Substation ☐				Process Improvement ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐			
Past Expiry Date ☐				Manufacturing Process ☐				Marks/Chatter ☐				Drill Holes ☐			
Misidentified ☐				Past Due ☐				OTHER: _____							

Picklist Print

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Page 1

Work Order ID: 159634

159634

Parent Item: D4634-045

D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 4/19/2017

Required Date: 5/3/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Document release DL VERIFIED BY:JLM
 Dwg Update DL verf: DD
 DL
 DL
 DL
 IPP Rev B
 IPP Rev C 13/07/09
 IPP Rev D Dwg Update 13/12/23
 IPP REV E Dwg update 14/01/09
 IPP Rev F Dwg. update 14/02/03
 IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2351-20-27-C3C	2351-20-27- Z3CT	Purchased	No			100	Each	47.0000	1	1		JUN 05 2017	

2351-20-27-C3C
 STUD

★★

DAS
6
9-89

Location	Loc Qty	Loc Code
ST579	47	
m128068	3	
m130318	44	

50-009-2

Purchased No

100

Each

40.0000

1

1

JUN 05 2017

DAS
6
9-89

50-009-2
 Grommet

★★

Location	Loc Qty	Loc Code
ST583	40	
m135442	40	

D4652-5

Manufactured No

100

Each

21.0000

2

2

JUN 05 2017

D4652-5
 Air Valve, 1.25 Id Disk Type

★★

Location	Loc Qty	Loc Code
MF003	21	
155417	21	

D4634-145

Manufactured No

100

Each

0.0000

1

1

D4634-145

Aft, Center Ceiling Replacement Panel Assembly

★★

3 159806

17/06/05.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other										
Part No. _____		☐ Rework ☐ Scrap ☐ Use-as-is		☐ Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab		☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier		☐								
NCR No. _____		☐ Suspected Unapproved																
Date: _____		Step #: _____		QTY Effective: _____						MRB (QS1042) Approval								
Description Work Order Deviation				Disposition				Completed By										
								Lead hand / Supervisor Approval Verification										
								QC / QA Coordinator Approval										
Root Cause				FAULT CATEGORY														
Environment				Pressure/Forced				Temperature/Cure				Power Loss/Surge						
☐ Design				☐ No Re-verification				☐ Bending				☐ Set-up				☐ Folio/Program		
☐ Doc/Data				☐ Operator				☐ Centre Not Concentric				☐ BOM/Route				☐ Grain		
☐ Equip/Tooling				☐ Offset/Setup				☐ Cracks				☐ Broken/Damage/Defect				☐ Weld		
☐ Handling/Pre				☐ Supplier				☐ Crimp/Kink/Ripple/Wave				☐ Inspection Incomplete/Unqualified				☐ Wrong Stock Pulled		
☐ Material				☐ Training				☐ Cuffs				☐ Contamination				☐ Out of Sequence		
☐ Internal Transport				☐ Use for Testing				☐ Crushing				☐ Countersink				☐ Off-set		
☐ Tribal Knowledge				☐ Poor Information				☐ Heat Treat				☐ Cut Too Short				☐ Mislabeled		
☐ LOA				☐ Rushing				☐ Wave/Twist in Tube				☐ Instructions Incomplete/Unclear				☐ Fit/Function		
☐ Substation				☐ Product Improvement				☐ Marks/Chatter				☐ Drill Holes				☐ Misaligned/off center		
☐ Past Expiry Date				☐ Process Improvement														
☐ Misidentified				☐ Manufacturing Process														
				OTHER:														

Picklist Print

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Page 2

Work Order ID: 159634

159634

Parent Item: D4634-045

D4634-045

Parent Item Name: Aft, Center Ceiling Panel Assembly

Start Date: 4/19/2017

Required Date: 5/3/2017

Start Qty: 1.00

Required Qty: 1.00

D4646-1 Manufactured No

100 Each 29.0000 2 2

D4646-1

Plenum Cap Assembly

**

JUN 05 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

MF009

29

154711

4

156116

25

2

D4728-049 Manufactured No

100 Each 15.0000 1 1

D4728-049

Advisory Light, Aft

**

JUN 05 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

over001

15

124736

15

1

D4728-055 Manufactured No

100 Each 9.0000 1 1

D4728-055

Cabin Lights #3

**

JUN 05 2017

Location

Loc Qty

Loc Code

MF003

9

122599

9

1

PLT1.5M-M Purchased No

100 Each 2,652.000 10 10

PI T1 5M-M

Tie Wrap

**

JUN 05 2017

Location

Loc Qty

Loc Code

ST585

2652

m129712

2652

10

DAS
6
9-89

DAS
6
9-89

DQA: _____ Date: _____

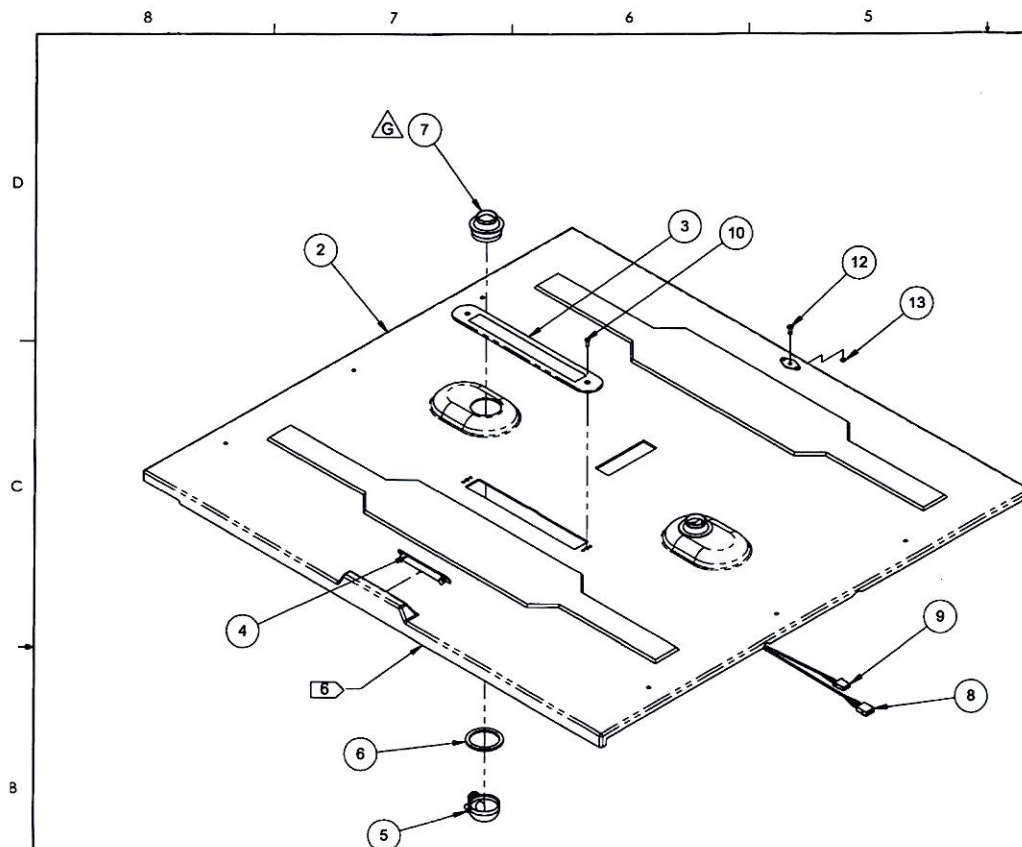


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							



ITEM NO.	QTY. -045	P/N	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-055)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-049)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
7	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
8	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
9	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4638-1)
11	10	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
12	1	2351-20-27-C3C	DZUS STUD, OVAL HEAD
13	1	50-009-2	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159634 MJS
1704-18

D4634-045 AFT, CENTER CEILING PANEL ASSY

RELEASED

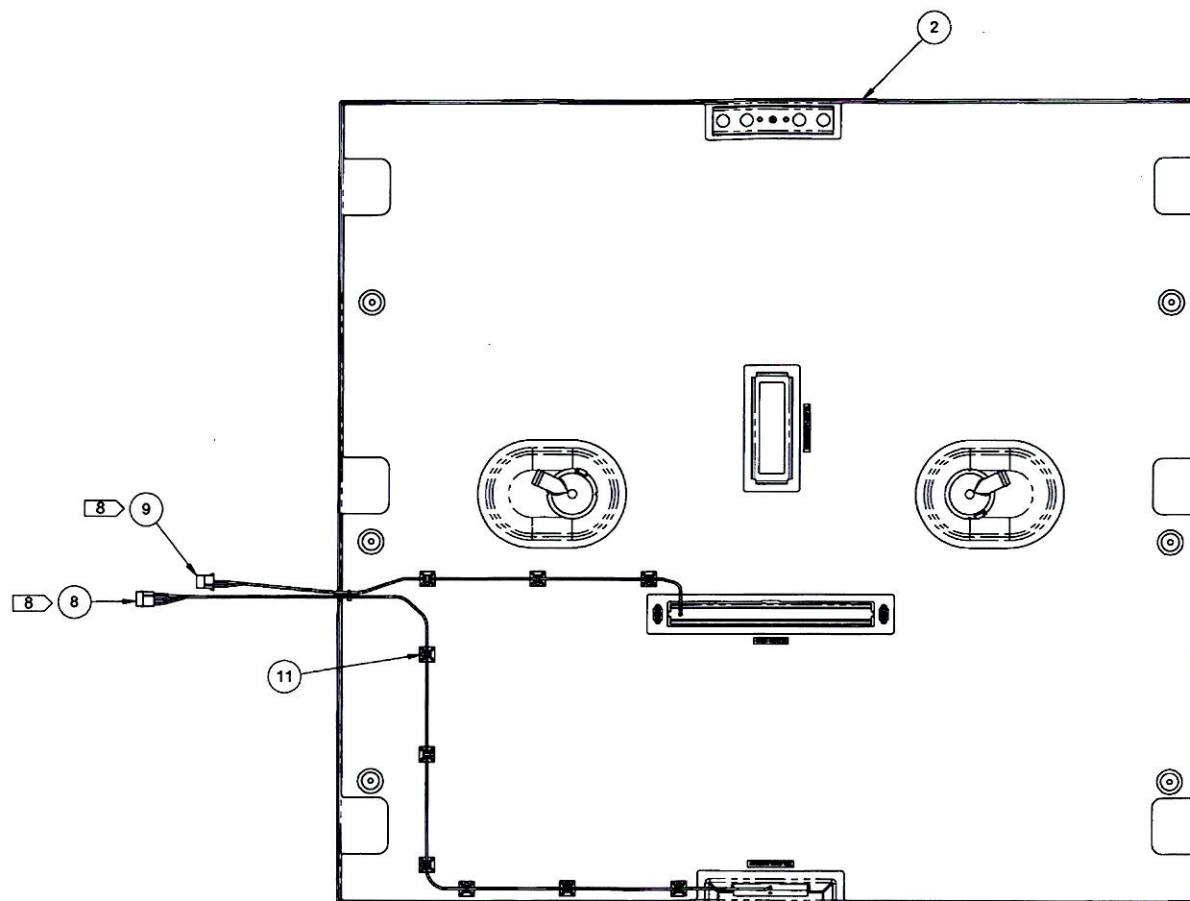
2015 JAN 26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.5 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G
MFG. APPR.	DL		SHEET 5 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4634-045 AFT. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED

2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 6 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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